



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85180**

Monday, June 04, 2012 11:03:56 AM

**\*85180\***

Page 2

Item ID: PB67-43001-205

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Outer Tube

Start Date: 6/4/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

130

Weld per dwg A/R Aluminum rod Batch: 120354 0.00**\*130\***

Large Fab

Memo

0.00

Large Fab

1-Weld end cap as per dwg PB67-43001  
2-grind end cap flush

140

QC10- Inspect visual per QSI004- ground welds 0.00

**\*140\***

QC

Memo

0.00

Quality Control

150

QC5- Inspect part completeness to step on W/O 0.00

**\*150\***

QC

Memo

0.00

Quality Control

12.06.25

CPL-12.06.25

12.06.25

**Dart Aerospace Ltd**

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**Work Order ID 85180**

Monday, June 04, 2012 11:03:56 AM

**\*85180\***

Page 3

Item ID: PB67-43001-205

Revision ID:

Item Name: Outer Tube

Start Date: 6/4/2012 Start Qty: 1.00

Required Date: 6/15/2012 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Sequence ID/  
Work Center IDOperation  
Description

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

**\*160\***

Packaging

Memo

Packaging

170

QC21- Final Inspection - Work Order Release

**\*170\***

QC

Memo

Quality Control

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***Stop **\*NR2\***Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

0.00

0.00

/K

JP  
12-6-26

12/6/26

MF  
12-06-25

**Dart Aerospace Ltd**

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# Picklist Print

Monday, June 04, 2012 11:03:55 AM

Page 1

Work Order ID: 85180

Parent Item: PB67-43001-205

Parent Item Name: Outer Tube

Start Date: 6/4/2012

Required Date: 6/15/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-24 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No			100	f	25.7484	3.615	3.8052632			
6061T6 RDTUBE 1.750 X 0.65W													

## Location

MAT016

108551  
109797  
110885  
111432

## Loc Qty

25.7484  
2.71  
2.6634  
16  
4.375

## Loc Code

M122146

PB67-43001-199

Outer Tube End Cap

Manufactured No

130 Each 21.0000

1

1

4.0 12-06-25

12-06-25

## Location

Mezz

44991

## Loc Qty

21  
21

## Loc Code

1

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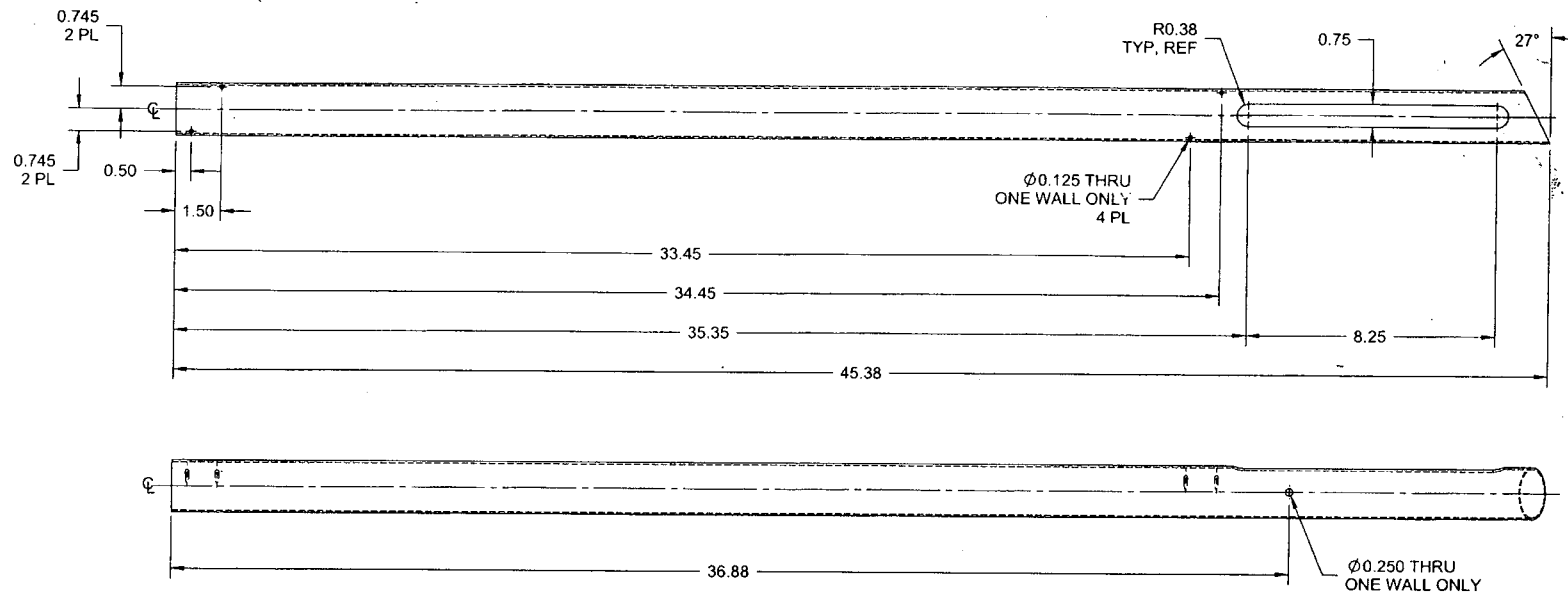
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# 85780



**B67-43001-205 OUTER TUBE**

**RELEASED**  
2009-09-24

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING  
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR  
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF. DART SPEC. M6061T6T1.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.46 lbs

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27
REV.		DESCRIPTION	BY	DATE	
DESIGN	R/W	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO. B67-43001-205		REV. C	
MFG. APPR.		TITLE		SCALE	
APPROVED		OUTER TUBE		NTS	
DE APPR.	N/A				
DATE	09.02.27	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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